

Work Order ID 69703

Tuesday, May 17, 2011 12:35:18 PM



Page 1

Item ID:	D3562-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Step Assembly, RH				Stop	
Start Date:	5/17/2011	Start Qty:	2.00			
Required Date:	5/27/2011	Req'd Qty:	2.00			
Reference:						

Cust Item ID:
Customer:

May 27th

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>11-05-17</i>	Tooling:	Date:		Run	Start	
	QC:		Date:		SPC (Y/N):	Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	Rev E								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding								
110		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

PL 11-05-18

PL 11-05-18

PL 11-05-18

2 *Ø*

2 *Ø*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Tuesday, May 17, 2011 12:35:19 PM

Page 3

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Stop

Item Name: Step Assembly, RH

Start Date: 5/17/2011 Start Qty: 2.00

Required Date: 5/27/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/RAluminum Rod M114703
2-Grind end cap welds flush as per Dwg D3562*11-05-19 2*

170

0.00



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

8/11/19

180

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

*8/11/19**(12)**RH*

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Tuesday, May 17, 2011 12:35:19 PM



Page 4

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Start Date: 5/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2RH ϕ M 4/08/19

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:20
320
11:50

2RH ϕ BL 11-5-19.

210

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

M 117315

2X ϕ M 4/10/20

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Tuesday, May 17, 2011 12:35:19 PM



Page 5

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Start Date: 5/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

X 2RH 0 Hld 11/05/20

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/05/20

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24
MK
11-05-20

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Tuesday, May 17, 2011 12:35:16 PM

[illegible]

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			100	Each	77.0000	1	2		11.05.18	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				HALL			6						
				64409			6						
				WA			71						
				46910			2						
				66970			69			2			
D2734  Step End Plate		Manufactured	No			140	Each	29.0000	2	4		11.05.18	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA015			29						
				66143			29						
D3560-042  Arm Weldment		Manufactured	No			140	Each	3.0000	1	2		11.05.18	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA013			3						
				48386			3			2			

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 17, 2011 12:35:16 PM

Page 2

Work Order ID: 69703



Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 5/17/2011

Required Date: 5/27/2011

Start Qty: 2.00

Required Qty: 2.00

D3560-044

Manufactured No

140

Each

4.0000

1

2



Arm Weldment



11.05.18

Location

Loc Qty

Loc Code

WA013

4

48388

4

2

MS20600-AD4W5

Purchased

No

160

Each

543.0000

32

64



11.05.18

Blind Rivet

Location

Loc Qty

Loc Code

ST321

537

114382

237

116289

100

117505

200

WA018

6

111477

6

64

Tuesday, May 17, 2011 12:35:16 PM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

D3562-1,
MAKE FROM
EXTRUSION D2622

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-044 ARM WELDMENT

D3560-042 ARM WELDMENT

D3562-1,
MAKE FROM
EXTRUSION D2622

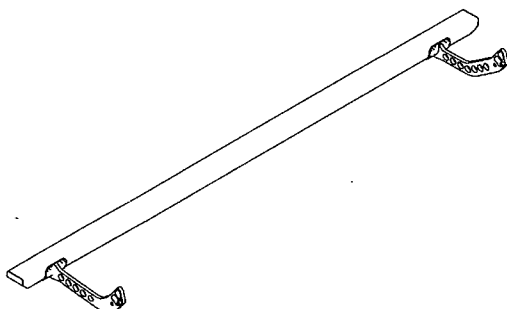
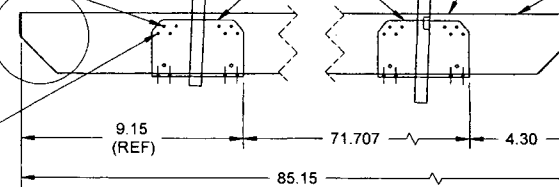
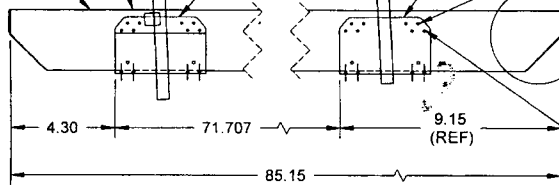
2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

TRANSFER DRILL #30
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING
(32 PLACES PER STEP)

REFER TO STEP
END DETAIL

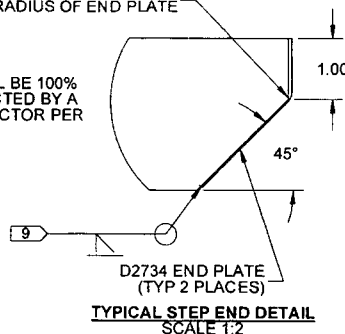
INSTALL MS20600AD4W5 RIVET
(32 PLACES PER STEP)



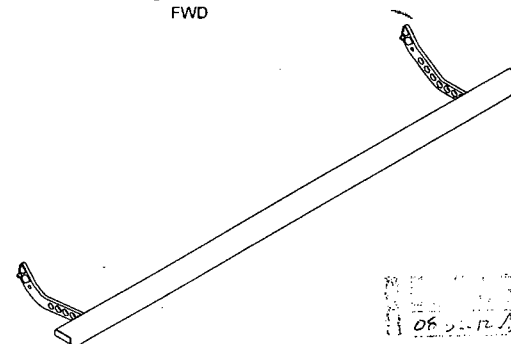
D3562-041 LH STEP ASSEMBLY

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
PART QSI 004



TYPICAL STEP END DETAIL
SCALE 1:2



D3562-042 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:

- i) CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY
- ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3562-041	LH STEP ASSEMBLY
		D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ef		
CHECKED	ke	DRAWING NO.	REV. E
MFG. APPR.	mp	D3562	SHEET 1 OF 1
APPROVED	mp	TITLE	SCALE
DE APPR.	mp	STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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